Page 1

February-14-13 2:56:02 PM Item ID: D3200-3 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Door Wedge Start Date: 2/14/13 **Start Oty: 12.00** \*12\* **Cust Item ID:** Required Date: 2/28/13 Rea'd Otv: 12.00 Customer: Reference: Run Start Process Plan: MLJ Approvals: Date: /3-02-/9 Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Code Otv Otv Number Stamp Draw Nbr **Revision Nbr** D3200 Rev A 100 0.00 BAND SAW \*100\* Bandsaw 0.00 Memo Jeaspa Bandsaw Cut blank: 1.000 X 1.970" 110 0.00 HAAS CNC VERTICAL MACHINING #1 \*110\* HAAS I 0.00 Memo HAAS CNC vertical machine #1 1-Machine D3200-3 as per Folio FA337 and Dwg D32002-Deburr QC2- Inspect parts off machine FAI/FAIB 0.00

OC

Memo

Quality Control

120

0.00

NCR: Y	es / No				WORK ORDER NON-C	CONFORI	MANCE / UPI	DATE	QA Closed:	Date	:		
Work Orde	r:				DISPOSITION	,	AGAINST DEPARTMENT/PROCESS						
Part No					Scrap Machining Smal			Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR No.					Work Order Update	]	Large Fab	Composite		Supplier			
Root					ption of work order update	Initial	i	tion	Sign &				
Cause	Date	Step	Qty	(	or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector		
Doc/Data													
quip/Tooling													
Operator						İ							
Material													
Setup													
Other													
Process		1											
Supplier	_								ļ				
Training													
Unapproved		<u> </u>			-	AULT CATE	CODY		<u> </u>	<u>L</u>			
1 41:-					r General	AULI CATE	GURT						
Landii	ng Gear Bending				Bend	Grain		<u></u>	Ovalized	Γ	Pressure/Forced		
	· Centre N	ot Conco	ntric to (	\s\ \-	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure		
	Cracks	ot conce	incre to t	)/3  -	Broken/Damaged	<b></b>	tion Incomplete		Part Incorre	<u> </u>	Weld		
	Crushed/Crimped.				Burrs	<del></del>	tions Incomplete/	Unclear	Part Lost/M	<b>├</b>	Wrong Stock Pulled		
	Cuffs Crusnea/Crimpea.			-	Contamination	<b>—</b>	enance		Part Moved	_	~		
	Heat Trea	at		<b>—</b>	Countersink	Mislab			Positioned \				
	Inspectio		Tube	<b> </b>	Cut Too Short	Misrea			Power Loss,		Other		
	Ripples in				Drill Holes	Offset		<u> </u>	<b>-</b>	- <b>L</b> .			
	——		Extrusion	,  -	Drawing	<del></del>	Calibration						
	Torque Waves in Extrusion Turning Sequence				Finish	Out of	Out of Sequence						

Outside Dirnensions

DQA: \_\_\_\_ Date: \_\_\_

Wave/Twist in Tube

Folio

February-14-13 2:56:02 PM

Page 2

Item ID: D3200-3 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Door Wedge Start Date: 2/14/13 **Start Qty:** 12.00 **Cust Item ID:** Required Date: 2/28/13 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: Stop SPC (Y/N): Date: \_\_\_\_\_ Date: Sequence ID/ Operation Set Up/ Tool # Plan Reject Tool ID Reject Accept Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 130 QC8- Inspect parts - second check 0.00 \*130\* 13/02/28 0.00 Memo Quality Control 140 Identify as per dwg & Stock Location: 0.00 \*140\* Packaging 0.00 Memo Packaging 150 QC21- Final Inspection - Work Order Release 0.00 \*150\* 0.00 Memo Quality Control

NCR: Ye	es / No				WORK ORDER NON-C	CONFOR	MANCE / UPI	DATE	QA Closed:	Date	:		
Work Orde	r:				DISPOSITION	,	AGAINST DEPARTMENT/PROCESS						
Part No.					Rework Scrap Use-as-is	- I	Skid-tube Machining moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR N	0			Work Order Update Large Fab Composite Supplier									
Root				Descri	ption of work order update	Initial	Act	tion	Sign &				
Cause	Date	Step	Qty	(	or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector		
Doc/Data		]								:			
quip/Tooling									,	l			
Operator											·		
Material .													
Setup 😁 🙉	_					ļ							
Other	_					1							
Process	_												
Supplier													
Training													
Unapproved									<u> </u>				
	•					AULT CAT	EGORY						
Landin	g Gear				General	<b>—</b> а.		_	1	Г	Pressure/Forced		
	Bending			<u> </u>	Bend	Grain		-	Ovalized	talarana	Temperature/Cure		
-	Centre No	ot Conce	ntric to C	<sup>)/S</sup>	BOM/Route	Hardw			Over/Under	<u> </u>	- Weld		
-	Cracks			-	Broken/Damaged	⊢—	tion ncomplete	11	Part Incorre	_	Wrong Stock Pulled		
-	Crushed/Crimped.				Burrs	-	ctions Incomplete/	Unclear	Part Lost/M				
	Cuffs			<u> </u>	Contamination	$\vdash$	enance	<u> </u>	Part Moved Positioned \				
-	Heat Trea		T. d	$\vdash$	Countersink	Mislak		<u> </u>	Power Loss		Other		
}	Inspectio		rupe		Cut Too Short	Misre: Offset		L_	Trower ross/	Juige [	Journel		
-	Ripples in			<u> </u>	Drill Holes	<b>⊢</b>	Calibration						
	Torque W			' <u> </u>	Drawing	<del></del>							
	Turning Sequence				Finish	L_Jout of	Out of Sequence						

Outside Dirnensions

DQA:

Date:

Wave/Twist in Tube

Folio

## **Picklist Print**

February-14-13 10:52:33 AM

Work Order ID:

97174

Parent Item:

D3200-3

Parent Item Name:

Door Wedge

**Start Date: 2/14/13** 

Required Date: 2/28/13

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			100	sf	624.4950	0.015	0.189474	<u> </u>	3 <b>-</b> 2-2	1

<b>Location</b>	Loc Qty	Loc Code	
MAT019	624.4949895		
121278	12.0949895		
122575	47.6		
123229	53		
123704	63.8		_
123949	26		
124167	7		
124380	22		_
124382	393		

122722

-2

NCR: Y	es /	No				WORK ORDER NON-C	ON	NFORM	MANCE / UPDATE		•			
											QA Closed:	Date	:	
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS		
Part No				Rework Skid-tube Crosstube Machining Small Fab Use-as-is Useras-is Large Fab Composite				Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			gineering Quality Other			
Root					Descri	ption of work order update	I	nitial	Action		Sign &			
Cause	(	Date	Step	Qty	c	or Non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup														
Other														
Process														
Supplier														
Training														
Unapproved											<u></u>			
						F.	AUL	T CATE	GORY					
Landi	ng Gea	r				General		_		_	-	_	_	
	Ве	nding				Bend		Grain			Ovalized		Pres	ssure/Forced
Centre Not Concentric to O/S			BOM/Route		Hardwa	re		Over/Under	tolerance		nperature/Cure			
	Cra	acks				Broken/Damaged		Inspect	ion incomplete		Part Incorre	ct	Wel	ld
	Cri	ushed/0	Crimped.			Burrs		Instruct	tions Incomplete/Unclear	L	Part Lost/M	issing	Wro	ong Stock Pulled
	Cuffs			Contamination		Maintenance			Part Moved					

Mislabeled

Out of Calibration

Out of Sequence

Outside Dirnensions

Misread Offset DQA:

Positioned Wrong

Power Loss/Surge

Other

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	97174
Description: Door Wedge	Part Number:	D3200-3
Inspection Dwg: D3200 Rev: A		Page 1 of 1

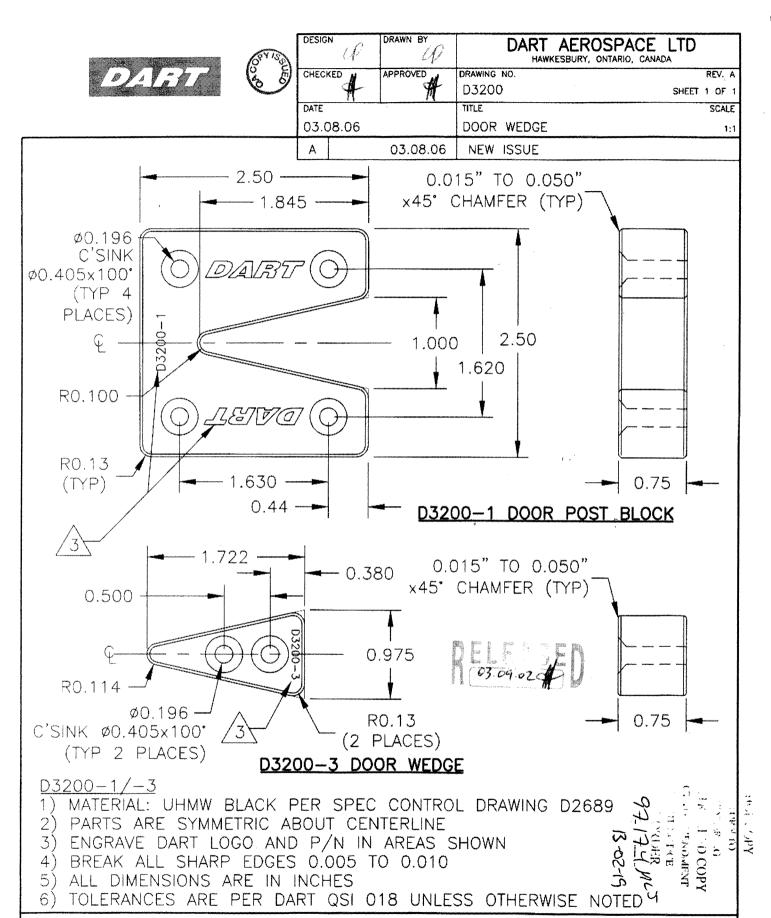
## FIRST ARTICLE INSPECTION CHECKLIST

	X	First Arti	cle _	Prot	otype
Drawing	Tolerance	Actual Accept		Reject	Method
Dimension	Tolerance	Dimension	Accept	Reject	Inspection

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension		_	Inspection	
Ø0.196	+0.005/-0.000	-196			vein 12-10	
0.405 x 100°	+/-0.010	-405X100°				
0.500	+/-0.010	-500				
1.722	+/-0.010	1.723				
0.380	+/-0.010	380				
0.975	+/-0.010	975				
0.750	+/-0.030	1.450				
0.015 - 0.050	N/A	-050				
			:			

		$\sim$ $\sim$ $\sim$		
Measured by:	Audited by:	80 25	Prototype Approval:	N/A
Date: 13-2-21	Date:	13/02/2889	Date:	N/A

Rev	Date	Change		Revised, by	Approved
Α	03.11.12	New Issue	P/O D412-698-015	KJ/RF ⊅	- 74
			***		



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